

### ABSTRACT OF THE DISCLOSURE

A method of forming a headliner includes overlaying a cover material onto a multi-layer substrate and at least partially separating the cover material from the substrate during the overlaying. The cover material is clamped separately from the substrate. The overlayed cover material and substrate are then transported into a mold. The substrate is unclamped while the cover material remains clamped, and the cover material and substrate are molded together to form the headliner.

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